

Work Order ID 69187 -3

Wednesday, May 04, 2011 11:17:53 AM



Page 1

Item ID: D3494-1

Revision ID:

Item Name: Stub Cover

Start Date: 5/4/2011 Start Qty: 13.00

Required Date: 5/5/2011 Req'd Qty: 13.00

Reference:

Approvals: Process Plan:

Date: 11054

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3494

Rev D

180



Waterjet

Memo

0.00

B11-5-4

FLOW CNC Waterjet

364.063

1-Cut as per Dwg

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

110



QC

Memo

0.00

B11-5-7

Quality Control

Work Order ID 69187

Wednesday, May 04, 2011 11:17:53 AM



Page 2

Item ID: D3494-1

Accept



Setup

Start



Revision ID:

Item Name: Stub Cover

Stop



Start Date: 5/4/2011 Start Qty: 13.00



Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 13.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S u105104

(14)

130



Brake NC

Bend as per dwg

0.00

SB u105111

(14)

Brake NC

Memo

0.00

140



Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S u105104

(14)

Memo

0.00



Work Order ID 69187

Wednesday, May 04, 2011 11:17:53 AM



Page 3

Item ID: D3494-1

Accept



Setup Start



Revision ID:

Item Name: Stub Cover

Stop



Start Date: 5/4/2011 Start Qty: 13.00



Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 13.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

144



Large Fab

Operation
Description

Weld per dwg A/R S.S. rod Batch: M117659

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

12

01-07-11 JB6/EZ

Large Fab

Memo

0.00

Large Fab

1- WELD
2- GRIND AS PER DWG

146



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S uctlu

0.00

147



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S uctlu

0.00

(+12)



Work Order ID 69187

Wednesday, May 04, 2011 11:17:53 AM

Page 4

Item ID: D3494-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Stub Cover

Start Date: 5/4/2011 Start Qty: 13.00



Required Date: 5/5/2011 Req'd Qty: 13.00



Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



Powdercoat

Powder Coating

Operation
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Memo

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Start Time : 9:00
 Temp : 320°F
 Finish Time : 9:30

12/5/11/07/12

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: 225

Memo

0.00

0.00

0.00

0.00

0.00

0.00

0.00



11/7/12 SP/RD

12/5/11/07/12

Work Order ID 69187

Wednesday, May 04, 2011 11:17:53 AM



Page 5

Item ID: D3494-1

Accept



Setup Start



Revision ID:

Item Name: Stub Cover

Stop



Start Date: 5/4/2011 Start Qty: 13.00



Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 13.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

180



Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

QC

Quality Control

Memo

0.00

11/7/13

MC
11-07-13

Picklist Print

Page 1

Wednesday, May 04, 2011 11:17:59 AM

Work Order ID: 69187



Parent Item: D3494-1



Parent Item Name: Stub Cover

Start Date: 5/4/2011

Required Date: 5/5/2011

Start Qty: 13.00

Required Qty: 13.00

Comments: IPP Rev:A New Issue 06-05-18 JLM
IPP rev B ecn 888 06.12.13 EC
add welding DD 10.03.03 verifie by:EC
chg design EC verified by:DD

IPP Rev:C

Ipp RevD ECN 10-555

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	108.5000	0.72	9.852632		BB1-5-4	

304/316 Sheet .063



Location Loc Qty Loc Code

MAT020 108.5

117275 108.5

117275

(14)

DART AEROSPACE LTD	Work Order:	69187
Description: Stub Cover	Part Number:	D3494-1
Inspection Dwg: D3494 Rev: D		Page 1 of 1

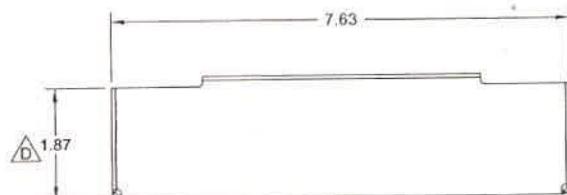
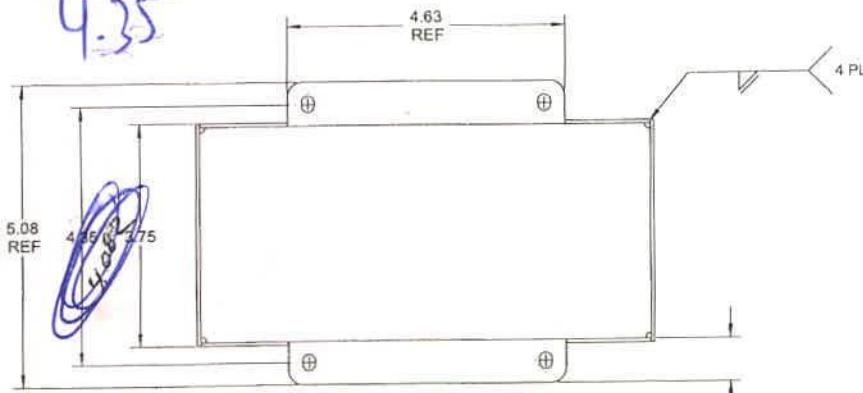
X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u>S</u>	Preliminary Approval:	
Date:	11-5-4	Date:	11/05/14	Date:	

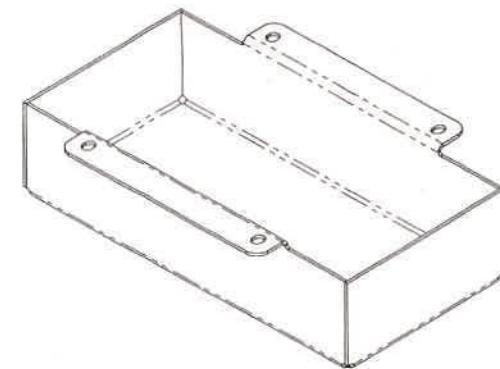
Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	10.02.18	Dimensions updated per Dwg Rev C	KJ	
C	11.04.28	Dimensions updated per Dwg Rev D	KJ	

8 7 6 5 4 3 2 1

4.35

D3494-1 STUB COVER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *CA181* *P04-054*



D

C

B

A

D

C

B

A

NOTES:

- 1) MATERIAL: MAKE FROM D3494-1F
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 01 INCHES UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.00 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3494-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.29 lbs
- 8) WELD PER DART QSI 004

8

7

6

5

4

3

2

1

D	TOLERANCE WAS 3 DEC. PLACES (ZN B5-1). 1.87 WAS 1.06 (ZN B8-1). 2.04 WAS 2.00 (ZN B3-1). REVISED D3494-1F (ZN A6-2). CORRECTED WEIGHT INFO (ZN A6-1). UPDATED MATERIAL (ZN A8-2). REASON SEE NCRM#10-037	MB	10.04.15
C	DRAWING TRANSFERRED TO "B" SIZE. GENERAL REVISION OF FLAT PATTERN SEE PREVIOUS REV FOR DETAILS. CB-1 DIM 5.08 WAS 5.05 AND WAS A "HARD CALLOUT". CS-1 0.87 DIM WAS 0.65. BB-1 1.90 DIM WAS 1.86 B3-1 & 2.04 DIM WAS 2.00. REFER TO PAR 08-003 FOR FURTHER DETAILS.	AJS	08.10.31
B	REVISED FLAT PATTERN. BENDING DIMENSIONS, $\phi 0.208 \times 0.268$ SLOTS WERE $\phi 0.208$ HOLES.	MB	08.11.28
A	NEW ISSUE	MB	06.01.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	REV. D	
MFG. APPR.	<i>[Signature]</i>	DRAWING NO.	D3494
APPROVED	<i>[Signature]</i>	SHEET 1 OF 2	
DE APPR.	<i>[Signature]</i>	TITLE	STUB COVER
DATE	10.04.15	SCALE	NTS

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2010-04-26
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